

Date: Tuesday, 07/04/2009 10:23:09 AM
 User: Julie Dawson

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : PLUG |
| Job Number : 46993 | |
| Estimate Number : 12338 | |
| P.O. Number : | Part Number : D34925 |
| This Issue : 07/04/2009 S.O. No. : | Drawing Number : D3492 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : C |
| Previous Run : 43452 | Material : |
| Written By : | Due Date : 14/04/2007 Qty: 40 Um: Each |
| Checked & Approved By : <u>JUD 09-04-07</u> | |
| Comment : Est Rev: A 06.03.21 New Issue JLM | |
| Est Rev: B 06-08-28 As per Rev B JLM | |
| Est Rev: C 07-12-06 as per rev c DD verified by: EC | |
| Est Rev: D 09-02-18 remove o'ring DD | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------|-------------------------|
| 1.0 | M6061T6R0500 | 6061-T6 Round Bar .500" |
|-----|--------------|-------------------------|



Comment: Qty.: 0.0656 f(s)/Unit Total: 2.6250 f(s)

6061-T6 Round Bar .500"

(M6061T6R500)

Batch: M109396Jul 09-04-13ml 09/04/13

(41)

| | | |
|-----|-----------------------------------|--------------------------|
| 2.0 | HARDINGE <u>DOOSAN</u> | HARDINGE CNC LATHE SMALL |
|-----|-----------------------------------|--------------------------|

Comment: ~~HARDINGE CNC LATHE SMALL~~

1-Turn as per Folio FA634 & Dwg D3492

Dwg Rev: CFolio Rev: N/Aml 09/04/13

(41)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/04/13

(41)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

N.A 09/04/13

(41)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:23:09 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 46993

Part Number: D34925

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary
2-Tumble

MR 09/04/13

(41)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/04/13

(41)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

98

09-04-14

(41)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M 110 939
(Flat End Only)

START TIME:

11:00

OVEN TEMPERATURE:

320°

FINISH TIME:

11:30

(41)

BR 09-04-15

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-15

(41)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-A

BR 09-04-15

(41)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



MF 09-04-15

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

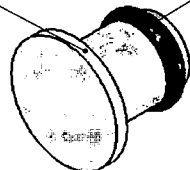
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -053 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X | | | | | | | D3492-041 | PLUG ASSEMBLY |
| | X | | | | | | D3492-043 | PLUG ASSEMBLY |
| | | X | | | | | D3492-045 | PLUG ASSEMBLY |
| | | | X | | | | D3492-047 | PLUG ASSEMBLY |
| | | | | X | | | D3492-049 | PLUG ASSEMBLY |
| | | | | | X | | D3492-051 | PLUG ASSEMBLY |
| | | | | | | X | D3492-053 | PLUG ASSEMBLY |
| 1 | | | | | | | D3492-1 | PLUG |
| | 1 | | | | | | D3492-3 | PLUG |
| | | 1 | | | | | D3492-5 | PLUG |
| | | | 1 | | | | D3492-7 | PLUG |
| | | | | 1 | | | D3492-9 | PLUG |
| | | | | | 1 | | D3492-11 | PLUG |
| | | | | | | 1 | D3492-13 | PLUG |
| | | 1 | | | | | NAS1611-005 | O-RING |
| | | | 1 | | | | NAS1611-007 | O-RING |
| 1 | | | | | | | NAS1611-010 | O-RING |
| | | | | | | 1 | NAS1611-012 | O-RING |
| | 1 | | | | | | NAS1611-013 | O-RING |
| | | | | | 1 | | NAS1611-015 | O-RING |
| | | | | 1 | | | NAS1611-016 | O-RING |

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~
06.04.05
OK ASS 08.11.12

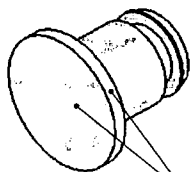
DEO ATTACHED

RELEASED
07.10.05

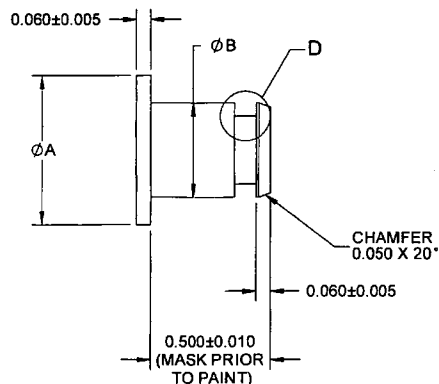
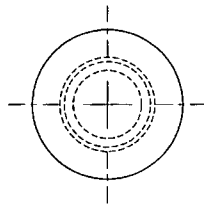
| | | | |
|------------|---|----|----------|
| C | ADD -049/-051/-053, CHANGE DRAWING FORMAT | PH | 07.10.05 |
| B | ADD -047; UPDATE DIM A FOR -045 | PH | 06.05.11 |
| A | NEW ISSUE | PH | 06.01.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.10.05 | | |

| | |
|--|--------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D3492 | REV. C |
| TITLE PLUG | SHEET 1 OF 2 |
| SCALE 2:1 | |
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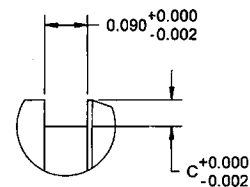
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NO. 16003



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-1 | 0.625 | 0.394 | 0.055 | M6061T6R0.625 |
| D3492-3 | 0.750 | 0.582 | 0.045 | M6061T6R0.750 |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.375 |
| D3492-7 | 0.500 | 0.270 | 0.045 | M6061T6R0.500 |
| D3492-9 | 0.938 | 0.750 | 0.045 | M6061T6R1.000 |
| D3492-11 | 0.850 | 0.664 | 0.045 | M6061T6R0.875 |
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

UNDER REVIEW

01.07.11
DESIGN BY D. J. J. J.
REV. 02 (HIVE SMALLER)
JSS 08.11.12
OK

DEO ATTACHED

RELEASED
07.11.16

| | | |
|--|-----------------|-----------------------------|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D3492 |
| MFG. APPR. | | REV. C |
| APPROVED | | SHEET 2 OF 2 |
| DE APPR. | | TITLE PLUG |
| DATE | 07.10.05 | SCALE 4:1 |
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| | | | | | | | |
|----------------------|------------------|------------------|---|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3492 | TITLE PLUG | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3492-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED | MFG. APPR. | APPROVED | | DE APPR. | | |
| DATE 08.11.05 | DATE 08.11.05 | DATE 08.11.05 | DATE 08/11/05 | | DATE 08/11/05 | | |

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.510 | 0.045 | M6061T6R0.750 |

WAS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

RELEASED
08/11/10

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